

Work Order ID 746854  
 Wednesday, October 05, 2011 9:58:35 AM

Item ID: D3602-1  
 Revision ID: Angle  
 Item Name: Angle  
 Start Date: 10/5/2011  
 Required Date: 10/11/2011  
 Reference:  
 Approvals: Process Plan: *mc*  
 QC:



Cust Item ID:  
 Customer:

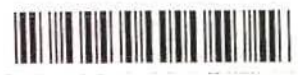


Date: Tooling: SPC (Y/N):  
 Date: Run Start Stop



Setup Start Stop

Accept



Sequence ID/ Work Center ID  
 Draw Nbr  
 Revision Nbr  
 Operation Description  
 Set Up/ Run Hours

100  
 FLOW WATER JET  
 Memo

1-Cut as per Dwg D3602  
 Dwg Rev: 1  
 Prog Rev: 2  
 Debur if necessary



QC2- Inspect parts off machine FA/FAIB

Memo

0.00



QC8- Inspect parts - second check

Memo

0.00

8 weeks

12/24

12/24

12/24

12/24

Tool ID Tool # Plan Code Qty Accept Qty Reject Qty Insp. Stamp



# Work Order ID 74685

Wednesday, October 05, 2011 9:58:35 AM



Page 2

Item ID: D3602-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

SP 11/6/26



Small Fab

Form as per Dwg D3602

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 u/10/26



150



Packaging

Packaging

Identify as per dwg & Stock Location 241A

Memo

0.00

0.00

10/10/26 SP

121

# Work Order ID 74685

Wednesday, October 05, 2011 9:58:35 AM



Page 3

Item ID: D3602-1

Accept



Setup Start



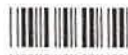
Revision ID:

Stop



Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27 *[Signature]*  
mfr  
11-10-26





# Picklist Print

Wednesday, October 05, 2011 9:58:31 AM

Page 1

Work Order ID: 74685

Parent Item: D3602-1

Parent Item Name: Angle



Start Date: 10/5/2011

Required Date: 10/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-27 JLM  
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

147.0795

0.585

12.31579



*12.31579*

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

147.0795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

59.5

*116623*

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*116623*

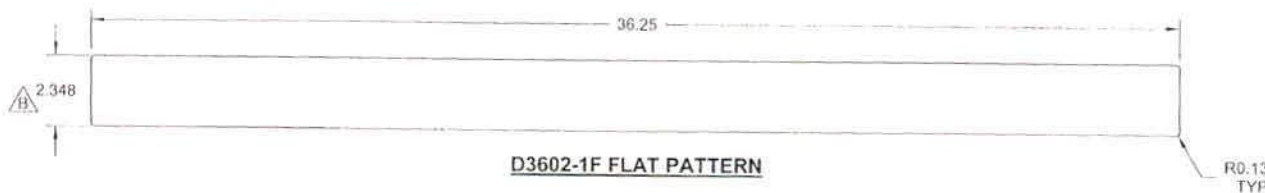
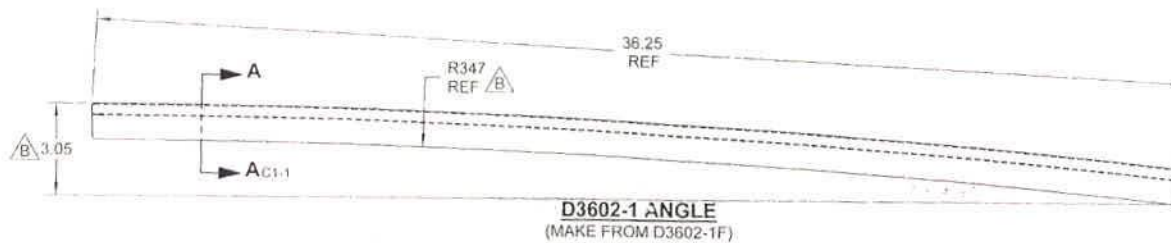
*24*











**RELEASED**  
01/03/11

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

# 74685

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3602

TITLE

ANGLE

SCALE

ITS

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE DISCLOSED OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

